Dart Aerospace Ltd.

Date: Monday, 3/19/2007 8:20:18 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH
Job Number	: 31282		
Estimate Number	: 10197		
P.O. Number	: N/A	Part Number	: D350607041
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 30858	Material	: N/A
Written By	:	Due Date	: 3/23/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.19		
Comment	: Est Rev:M 05.09.02 Added D2856-400-720 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-041 CHG006 ✓ KJ 07.06.06 (1)

2.0	31282A	BASKET BASE ASSEMBLY (350)

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B 31282A ml 07/07/25

3.0	31282B	350/212/130 BASKET LID

Comment: Sub-Component 350/212/130 BASKET LID
D2512 B 31282B ml 07/07/25

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

5.0	D2022101	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2022-101 Spacer B30543

07/07

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 31282 **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2258-200 Label B32276

7.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B31694

8.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B31787

9.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B31486

10.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B31107

11.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2728-3 Label B22553

07/07/25

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31282
Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

Seq. #:	Machine Or Operation:	Description :
13.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M104093

Seq. #:	Machine Or Operation:	Description :
14.0	AN47A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-7A	Bolt	M102140

Seq. #:	Machine Or Operation:	Description :
15.0	AN422A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-22A	Bolt	M102959

Seq. #:	Machine Or Operation:	Description :
16.0	AN424A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
1	AN4-24A	Bolt	M101938

Seq. #:	Machine Or Operation:	Description :
17.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M104016

07/07/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH

Job Number: 31282 **Part Number:** D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
18.0	AN960JD8	Washer
19.0	AN960JD416	Washer
20.0	AN960JD416L	Washer
21.0	AN960JD516	Washer
22.0	AN9704	Washer
23.0	MS20600AD4W3	Cherry Rivets

18.0 AN960JD8 — Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M104156

19.0 AN960JD416 — Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416 Washer M104215

20.0 AN960JD416L — Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M104214

21.0 AN960JD516 — Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M104156

22.0 AN9704 — Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

23.0 MS20600AD4W3 — Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M104715

07/07/2007

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31282
Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	MS21042L3	Nut (or -3)	M104547

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L4	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	MS21042L4	Nut (or -4)	M102552

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	MS21042L5	Nut (or -5)	M104118

07/07/25

Seq. #:	Machine Or Operation:	Description :
27.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607

Seal support gusset seam with white sikaflex-291 Batch: M104732
Expiry date: 10/2007

ml 07/07/25

Seq. #:	Machine Or Operation:	Description :
28.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

EP 07/07/25

Seq. #:	Machine Or Operation:	Description :
29.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31282
Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
30.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-1	Lug	B30992

Seq. #:	Machine Or Operation:	Description :
31.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Clamp	B30993

Seq. #:	Machine Or Operation:	Description :
32.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	*D2324-1	Strut Ass'y	B31270

Seq. #:	Machine Or Operation:	Description :
33.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2856-400-720	Abrasion Strip	B32992

Seq. #:	Machine Or Operation:	Description :
34.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN4-12A	Bolt	M104547

Seq. #:	Machine Or Operation:	Description :
35.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-13A	Bolt	M104746

07/07/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: [signature] Date: 07/07/20

QA: N/C Closed: _____ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH

Job Number: 31282

Part Number: D350607041

Job Number:

Seq. #:	Machine Or Operation:	Description :
36.0	AN960JD416	Washer
	Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 26 AN960JD416 Washer M107215	
37.0	MS21042L4	Nut
	Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 13 MS21042L4 Nut (or -4) M102552	
38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	
39.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D350-607-041 Location: REV: C	
40.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion

Dart Aerospace Ltd

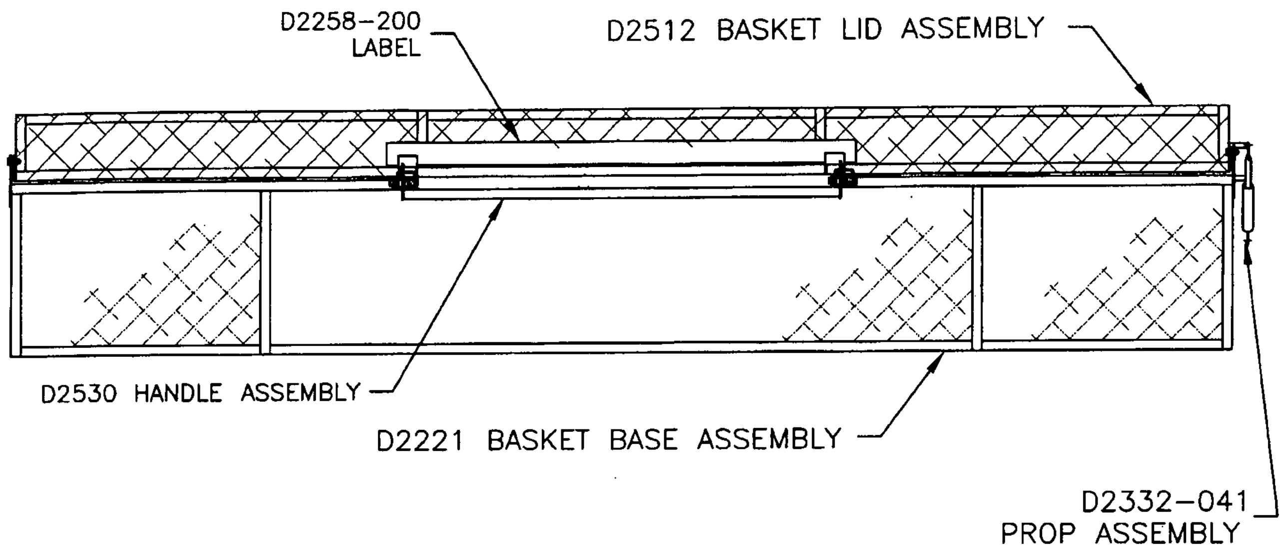
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

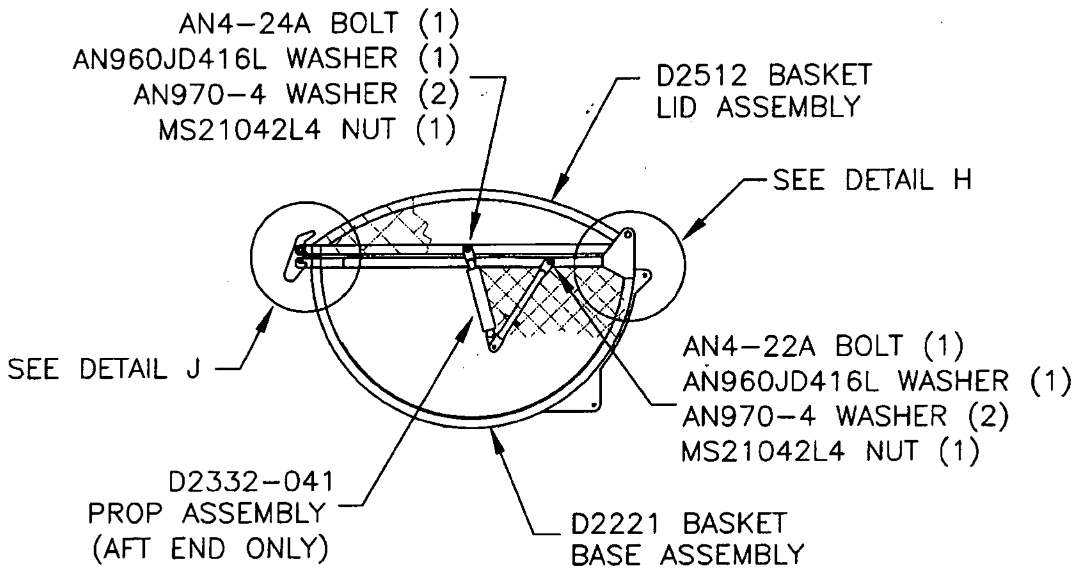
Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

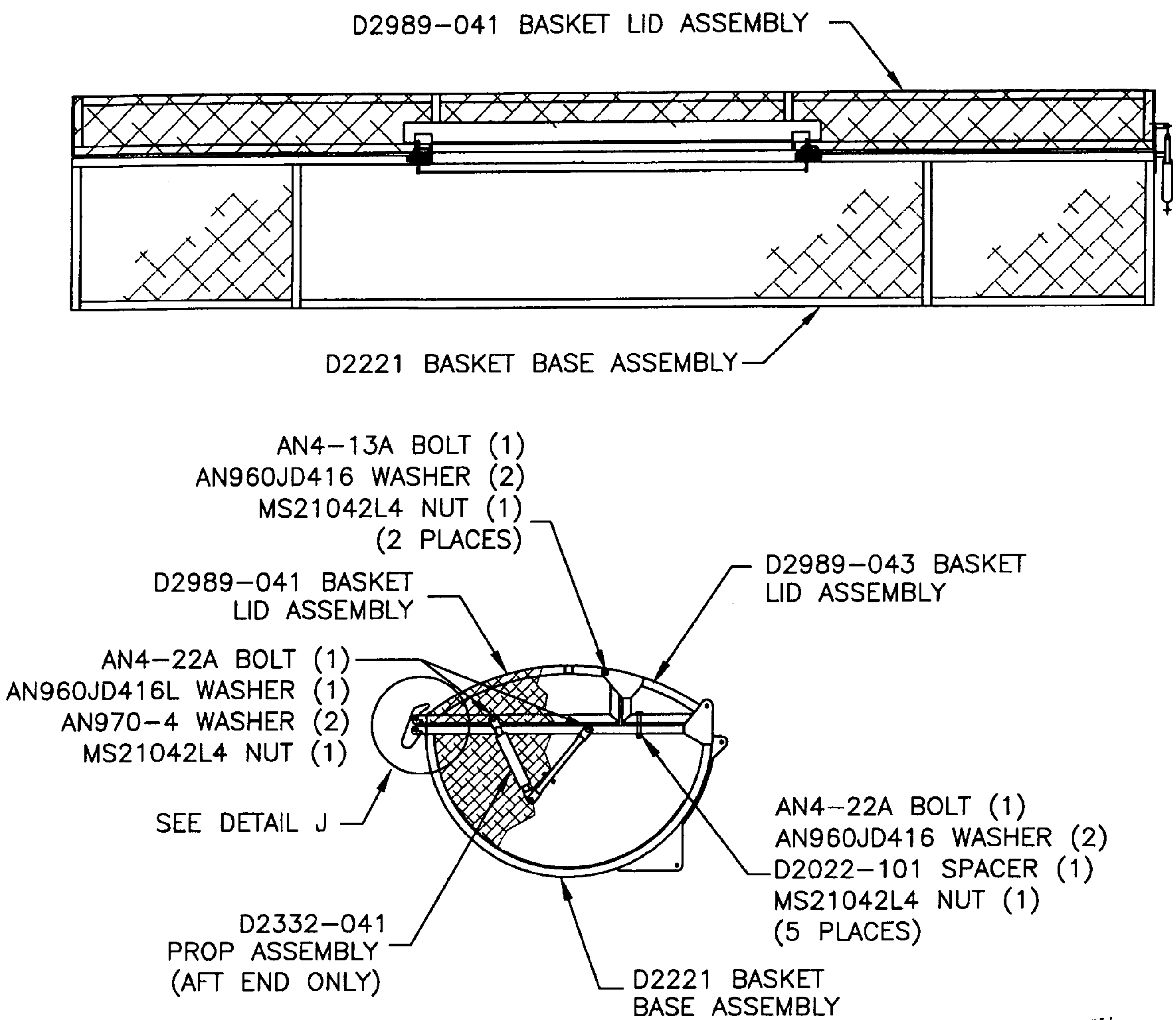
NOTE: Date & initial all entries





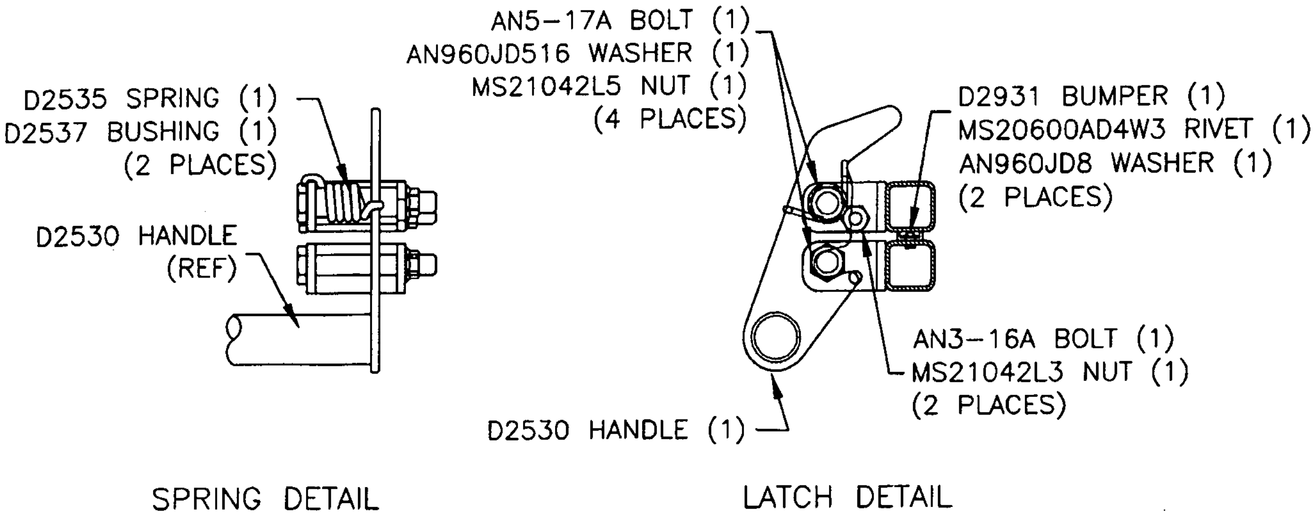
PROP ARM DETAIL
(VIEW C-C)

Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

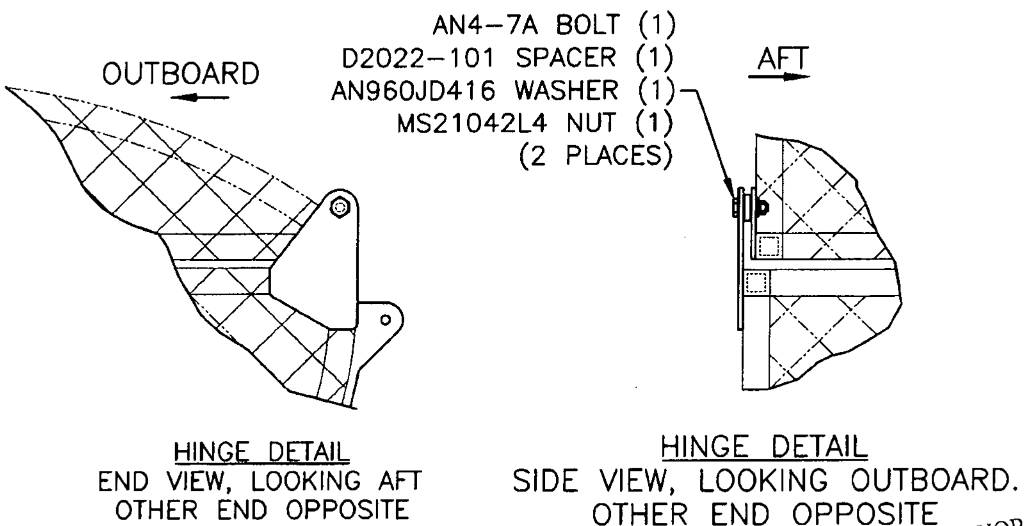


PROP ARM DETAIL
VIEW C-C

Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

Date: Monday, 3/19/2007 8:20:40 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 31282A		
Estimate Number	: 10189		
P.O. Number	: N/A	Part Number	: D2221
This Issue	: 3/19/2007 S.O. No. : N/A	Drawing Number	: D2221/D2235
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F/B1
Previous Run	: 30858A	Material	: N/A
Written By	:	Due Date	: 3/23/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.03.19		
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B32067

07/07/19

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B31784

07/07/19

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B32571

07/07/19

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B30876

07/07/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 31282A | Part Number: D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2581 Mounting Bracket B31189

AA 07/07/19

Seq. #:	Machine Or Operation:	Description :
6.0	D34421	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D3442-1 Shim B32875

AA 07/07/19

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:
Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M103409

AA 07/07/19

Seq. #:	Machine Or Operation:	Description :
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M104980

AA 07/07/19

Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

02/07/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/07/26

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 31282A
Part Number: D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	PD 07-07-23 (1)
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	PD 07-07-23 (1)
12.0	POWDER COATING	POWDER COATING
	m 105068	(1)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	BK / PL 07-07-24
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	ml 07/07/25
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(1) D 07/07/26

Job Completion

L 07/07/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

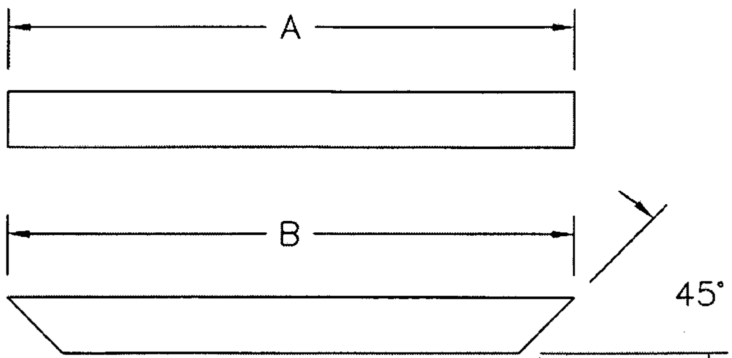
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2221 REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS

RELEASED 05.08.19

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

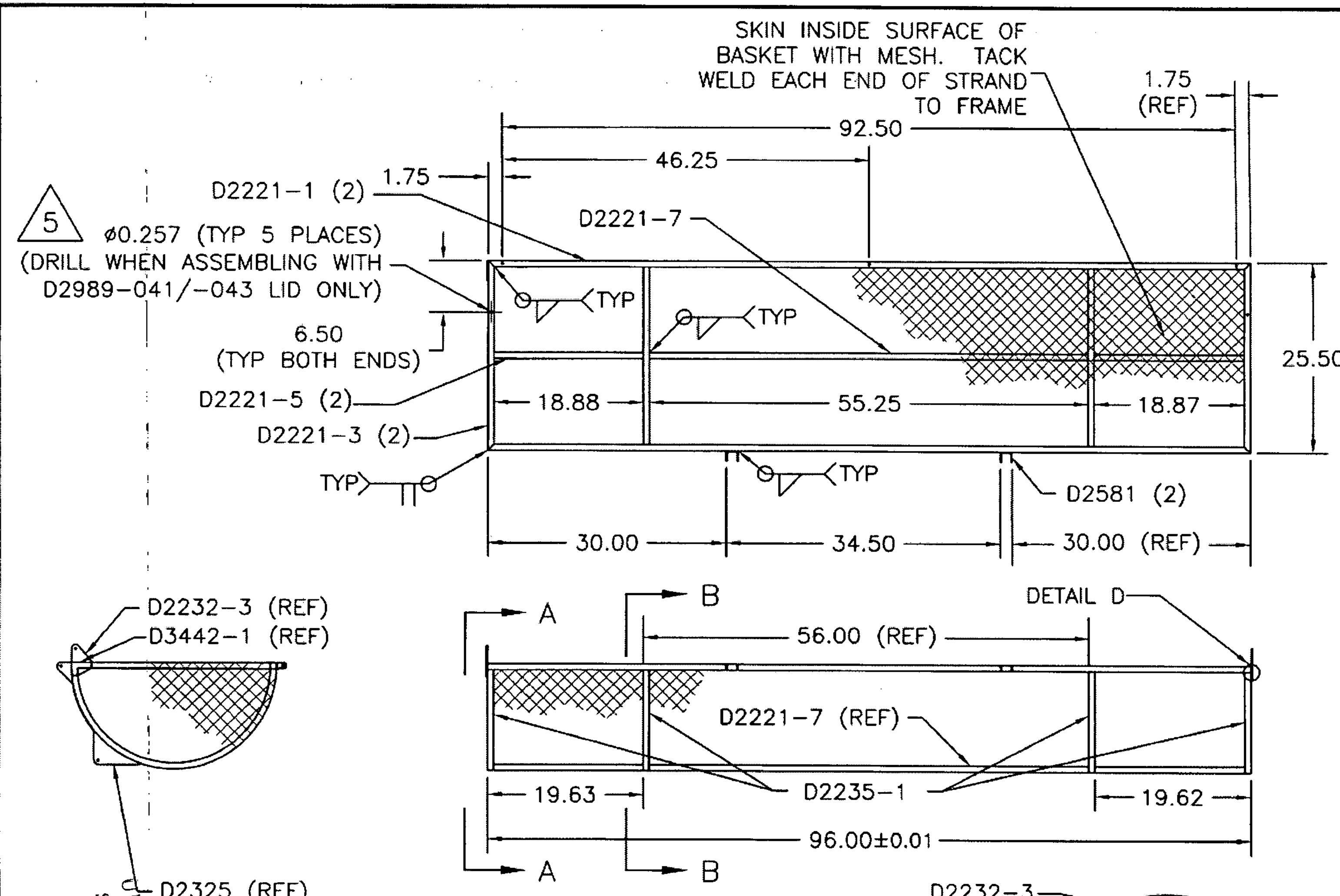
PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

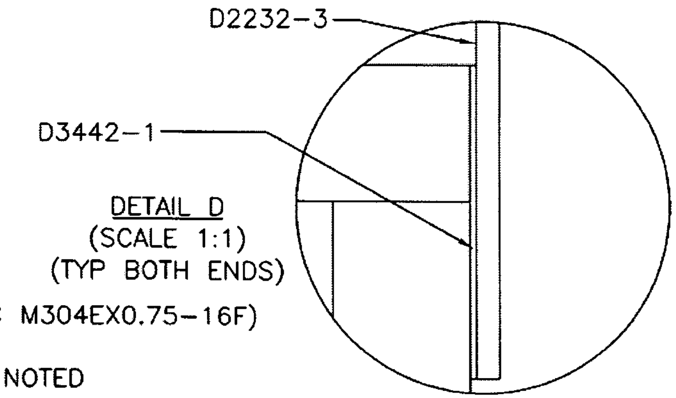
PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	——	96.00	RIB
D2221-3	2	——	25.50	RIB
D2221-5	2	18.88	——	RIB
D2221-7	1	55.25	——	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID





DETAIL D
(SCALE 1:1)
(TYP BOTH ENDS)

D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

DART

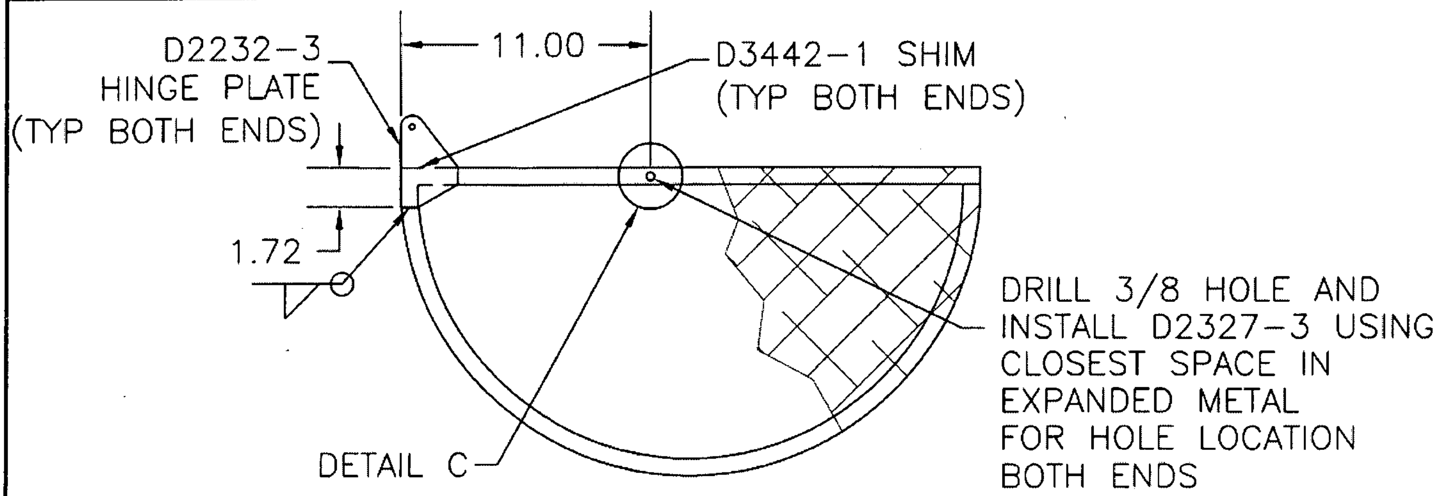
DESIGN	DRAWN BY
BW	PH
CHECKED	APPROVED
DATE: 05.06.07	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

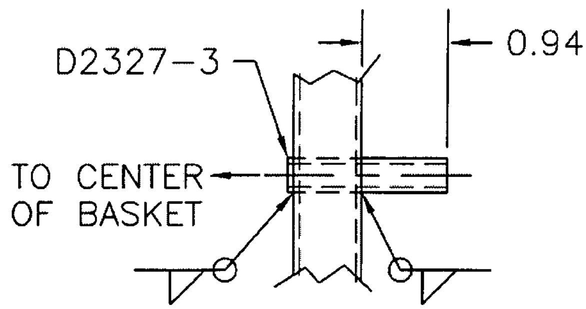
DRAWING NO. D2221 — REV. F — SHEET 2 OF 3

TITLE: BASKET BASE ASSEMBLY (350) — SCALE 1:20

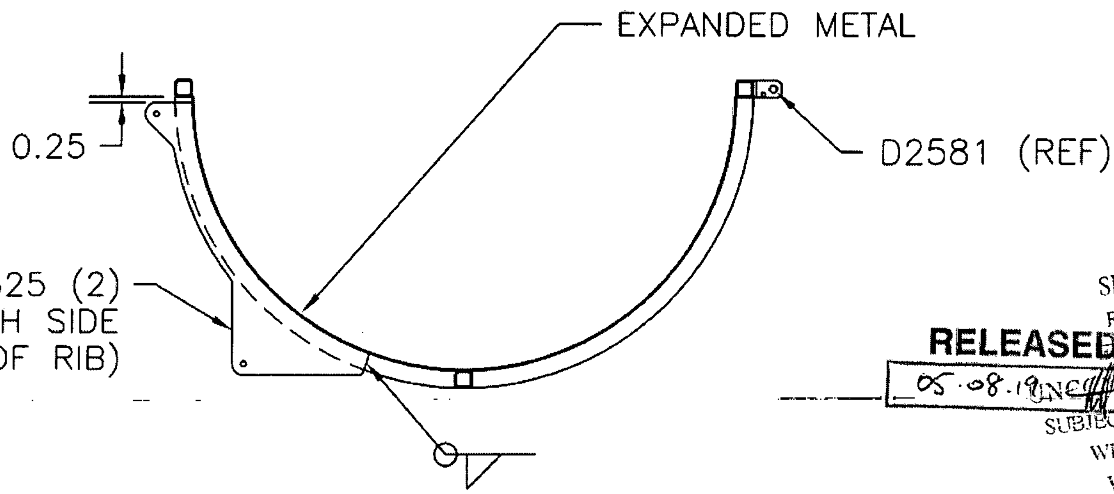
DESIGN BW	DRAWN BY PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A–A SAME BOTH END RIBS



DETAIL C



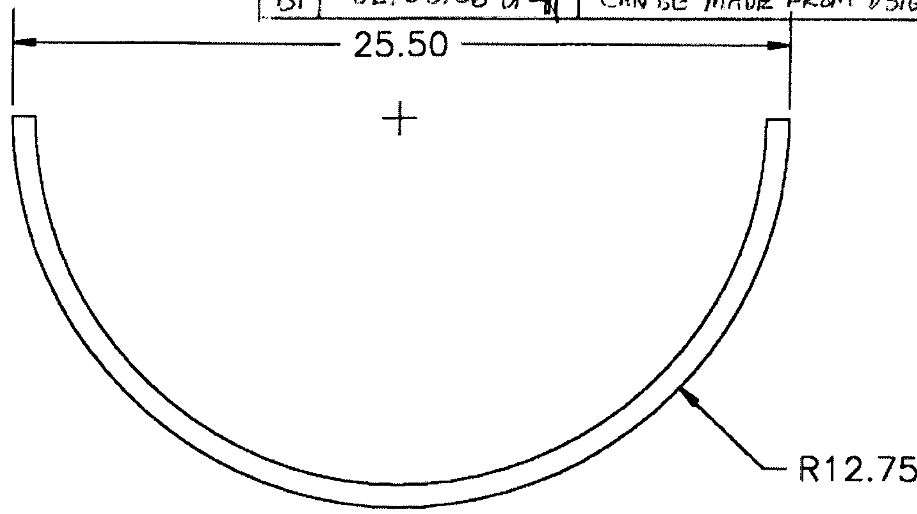
SECTION B–B SAME BOTH CENTER RIBS

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	B WILLIAMS	
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS — SCALE
B1	02.08.06	CAN BE MADE FROM D3166-1

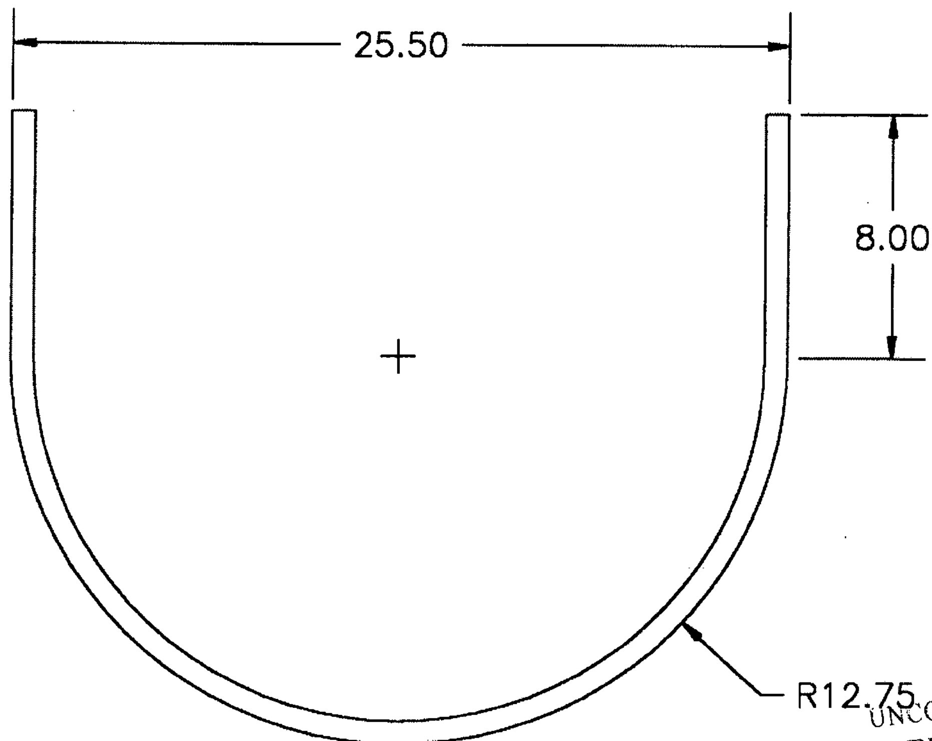
DART

QA COPY

RELEASED 960507



D2235-1



D2235-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 31282A

CAN BE MADE FROM D3166-1 B1

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

Date: Monday, 3/19/2007 8:20:59 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350/212/130 BASKET LID
Job Number	: 31282B		
Estimate Number	: 10193		
P.O. Number	: N/A	**Part Number**	: D2512
This Issue	: 3/19/2007 **S.O. No.** : N/A	**Drawing Number**	: D2512 REV D2
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: D2
Previous Run	: 31096A	**Material**	: N/A
Written By	:	**Due Date**	: 3/23/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.03.19		
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF Est Rev:N 06.04.05 Added level21 EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)
Pick:
3/4"x3/4" 304/316 SS tube .063" wall
Batch: M 104980

07/07/19

Seq. #:	Machine Or Operation:	Description :
2.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3166-3	Basket Hoop	B32068

07/07/19

Seq. #:	Machine Or Operation:	Description :
3.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2506	Label Plate	B31786

07/07/19

Seq. #:	Machine Or Operation:	Description :
4.0	D23271	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-1	Bushing	B28334

07/07/19

Form: rprocess

…rospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 3/19/2007 8:20:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350/212/130 BASKET LID

Job Number: 31282B **Part Number:** D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-1	Hinge plate	B29535

M 07/07/19

Seq. #:	Machine Or Operation:	Description :
6.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B31189

M 07/07/19

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)
Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M103409

M 07/07/19

Seq. #:	Machine Or Operation:	Description :
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

M 07/07/20

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION PD 07-07-23 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK PD 07-07-23 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** [signature] **Date:** 02/07/26

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 8:20:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350/212/130 BASKET LID

Job Number: 31282B **Part Number:** D2512

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING

m 105068

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR / FJ. 07-07-24

Seq. #:	Machine Or Operation:	Description :
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: m 104942.

Spray: m 104941

FJ 07/07/25 ①

Seq. #:	Machine Or Operation:	Description :
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/07/25

Seq. #:	Machine Or Operation:	Description :
14.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

ml 07/07/25

Seq. #:	Machine Or Operation:	Description :
15.0	QC21	FINAL INSPECTION/W/O RELEASE

①

Comment: FINAL INSPECTION/W/O RELEASE

07/07/26

Job Completion

07-07-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2512 — REV. D — SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) — SCALE NTS

DART

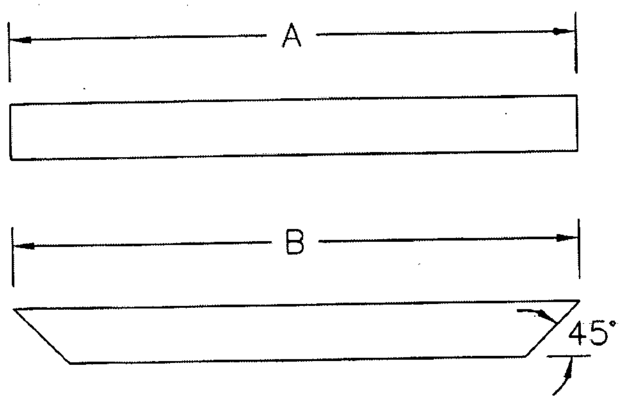
QA COPY ISSUED

RELEASED 01.04.27

REV	DATE	DESCRIPTION
A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	03 01. 20	ADD D2012-117 FOR D130-701-041
D2	04.09.20	TACK WELD ANTI-SKID AREA

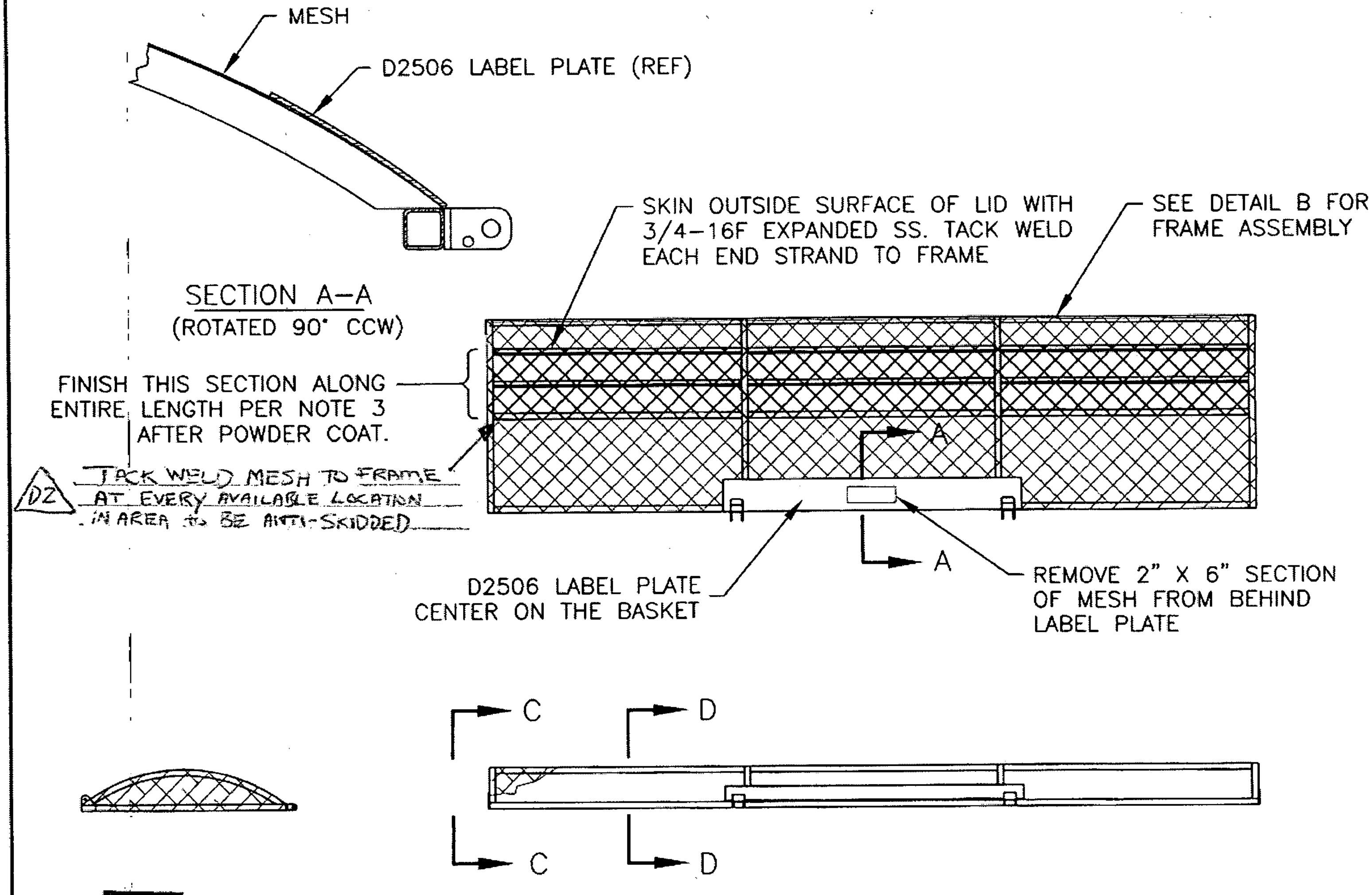
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	——	25.50	RIB
D2512-3	2	——	95.30	RIB
D2512-5	6	30.84	——	RIB
D2512-7	3	30.63	——	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31282B

D2512-1/-3/-5/-7
CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



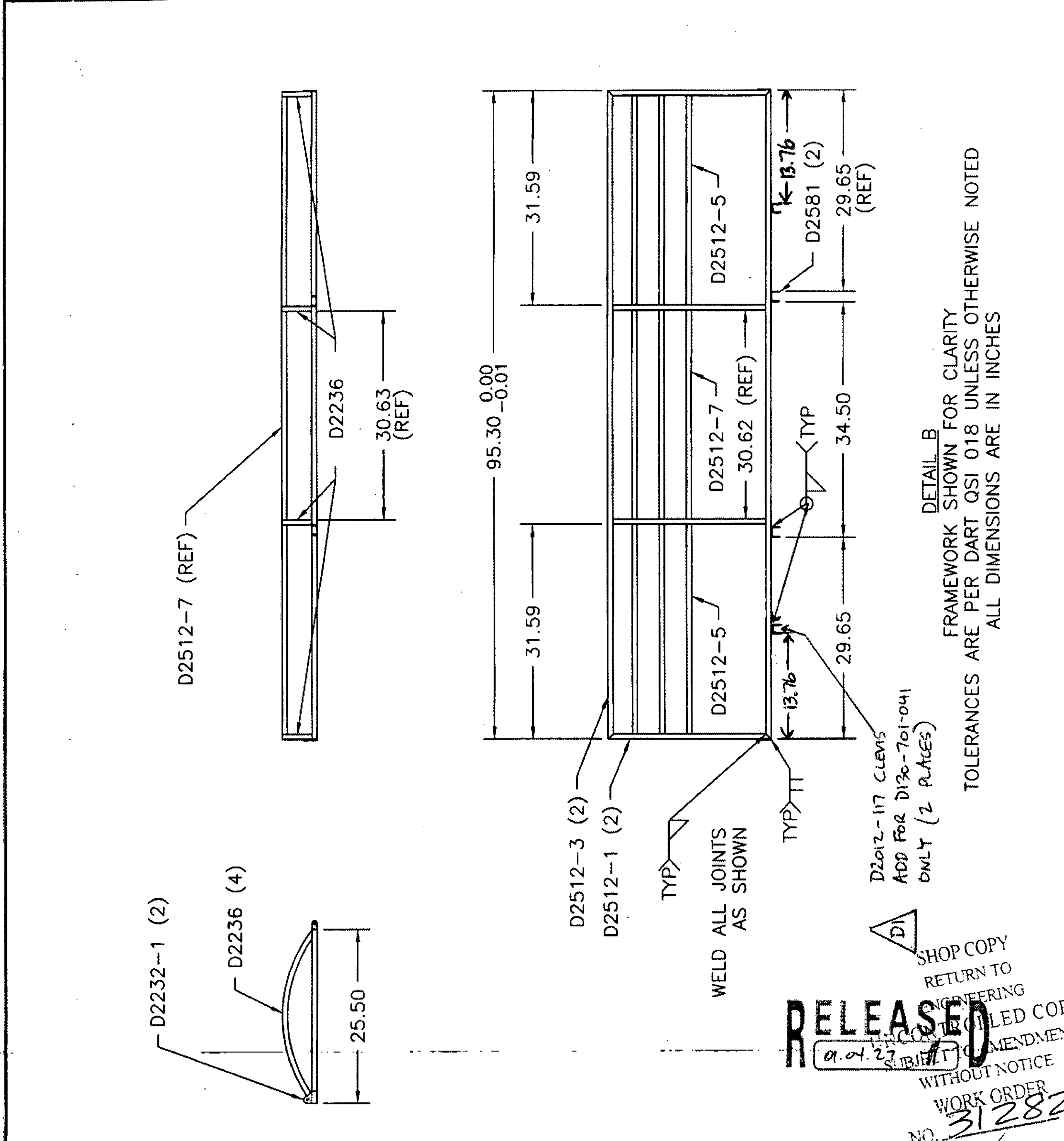
D2512 BASKET LID ASSEMBLY

1) MESH MATERIAL: 3/4–16F EXPANDED SS
2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
3) SPRAY PAINT BLACK INSIDE SURFACE
   APPLY BLACK ANTI–SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

DART
QA COPY ISSUED

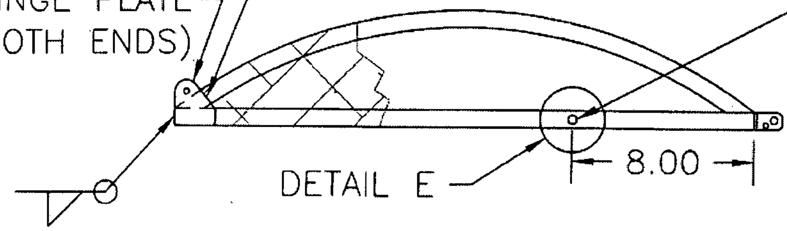
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW		
CHECKED	APPROVED	DRAWING NO. D2512 — REV. D — SHEET 2 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) — SCALE 1:20

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	[signature]	
CHECKED	APPROVED	DRAWING NO. D2512 — REV. D — SHEET 3 OF 4
[signature]	[signature]	
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) — SCALE 1:20

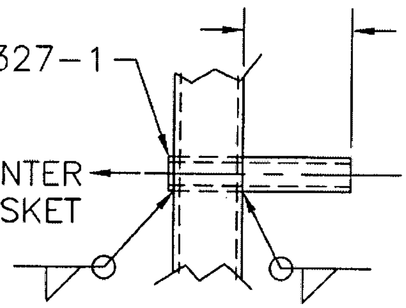


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

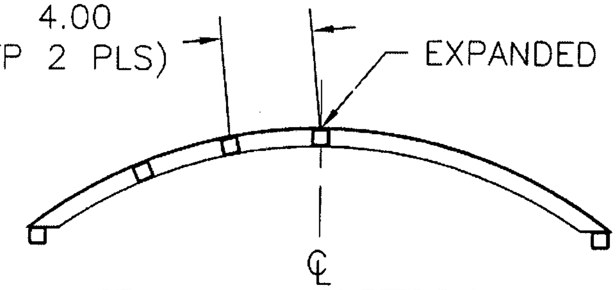
DART



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS